

# Work Order ID 56419

February 23, 2010 11:52:08 AM



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Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 25/02/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 05/03/2010 Req'd Qty: 40.00



Customer:

Reference:

*10.02.23*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-25 Cap as per Folio FA387□2-Deburr

*SD 10/02/27*

*49* *0*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SA 10/02/27*

*49* *0*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*B.A 10/02/28*

*49* *0*

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Item ID:	D3121-241	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bearing Assembly					
Start Date:	25/02/2010	Start Qty:	40.00		Cust Item ID:	
Required Date:	05/03/2010	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Identify as per dwg & Stock Location: <u>235B</u>								
Packaging	Memo	0.00							
Packaging									

*EP 510/03/10* (49)

*510/03/10*

*counters*  
(49)

*2/23/11* (49)

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Item ID: D3121-241

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearing Assembly

Start Date: 25/02/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 05/03/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 HJ

MK  
10-3-11

# Picklist Print

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Work Order ID: 56419

Parent Item: D3121-241

Parent Item Name: Bearing Assembly

Comments: IPP Rev:A 04.02.18 New issue KJ/DS  
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Start Date: 25/02/2010

Required Date: 05/03/2010

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-23		Manufactured	No			100	Each	44.0000	40.0000			



Bearing

4510/03/10

B56591 (84)

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	44	
----	----	--

46850	1	
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47676	43	
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MDELNR1.2500

Purchased

No

130

f

4.3240

2.1895



DELIN ROUND BAR 1.25

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

MAT	4.324	
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110236	4.324	
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110235

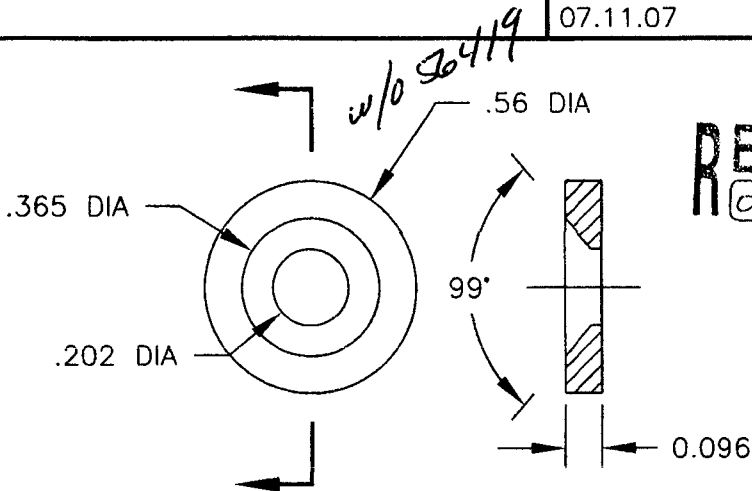
no 1.25 net 1.5"  
in  
shock  
SA  
10/02/27

3 R+ SA 10/02/27

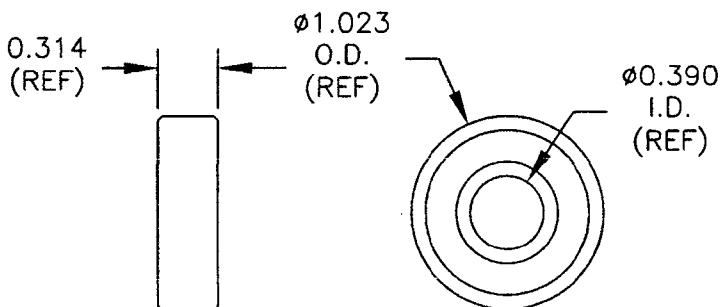


**DART**

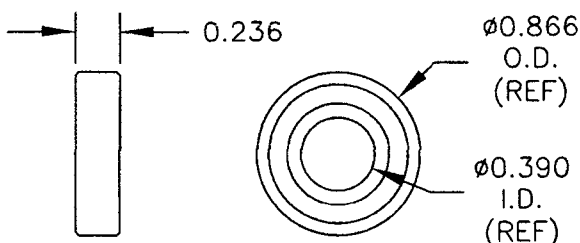
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

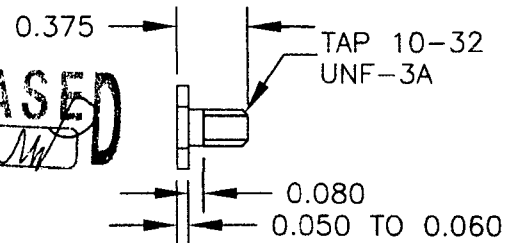
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

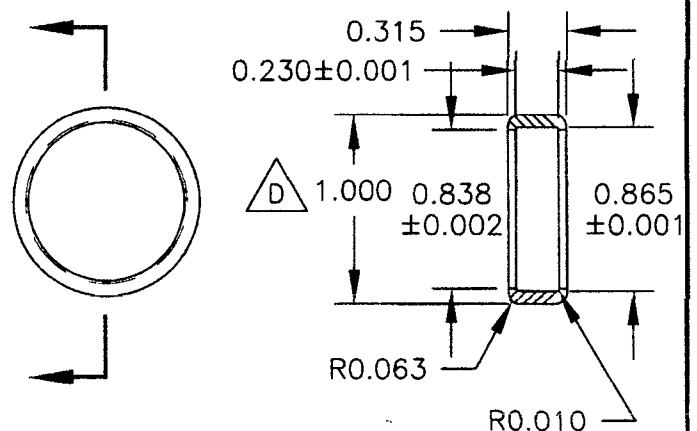
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

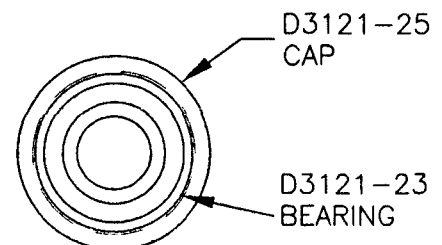
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.11.07**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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